



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-3700-A
Job Sheet 194556



DAS
21
9-89

Part No: RBE350A94-3700-A

Job Qty: 10 pcs

Part Name: Swashplate Immobilizing Tools Long Brace & Parts



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/3/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-3700-A Rev 7 IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	10 pcs	6/14/19		0.00	1.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	10 pcs	6/14/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	10 pcs	6/14/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S187059



Part: RBE350A94-3700-A

Job No: 194556

Serial No/Batch: S187059

Revision: 7

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/04/19

DAS
40
9-89

JUN 04 2019

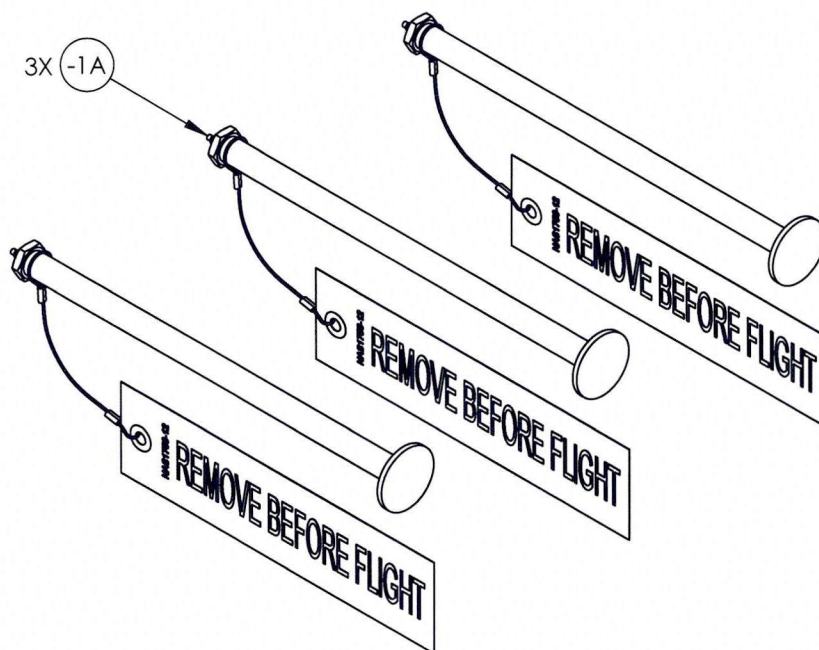
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				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	10 pcs	6/14/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	DAS
				QC 21 - SA - 53	21
Part Op 110 - (Small Fab) Pick, bag and tag. Descriptions: 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
RBE350A94-3700-A-1A	Long Brace Assembly	30 pcs (3 ea)	110-Small Fab - 1	5186753	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Small Fab - 1	RBE350A94-3700-A-1A	30	0	0	
Part Specifications					
Specifications could not be found.					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		BROKE OUT FROM KIT AS INDIVIDUAL TOOL.	8/21/2012	RJC	RW
5		-03 ADDED P.F. -01 TO CAP PIN. -05 ADDED P.F. -01 TO FOOT PIN DIAMETER.	4/17/2013	CFS	GE
5A		CH'D T/N WAS RBEA94-3700-A IS RBE350A94-3700-A, DELETED ASSY. FROM TOOL NAME.	10/23/2013	CFS	RW
6	15-0212	-A DELETED ENGRAVE NOTE, CHD DIM WAS 14.60 IS 14.60 ±.02. -01 CH'D OAL WAS 14.173 IS 14.164. ADDED ENGRAVE NOTE.	8/14/2015	RJC	JAG
7	16-0282	ADDED USED IN KITS NOTE. -1A ADDED TO BOM QTY: 3. ADDED DRAWING. -01 , -03 , -05 ADDED FINISH BLACK OXIDE QMSI-6.2.2, B.O. REV D. -01 ADDED DIMS Ø.6040-.6047 (P.F. -.03), .88, Ø.6040-.6047 (P.F. -.05), .88. CH'D MAT'L WAS STEEL IS DOM. -03 CH'D DIMS WAS .04 IS 2X .04, WAS P.F. -01 IS Ø.6052-.6056 (P.F. -01). -05 CH'D DIM WAS P.F. -01 IS Ø.6052-.6056 (P.F. -01). CH'D MAT'L WAS 1018/1020 IS 1018/1020 CR. -09 QTY: 1, -11 QTY: 1, -13 QTY: 2 ADDED TO -1A ASSY.	1/3/2017	DPD	JAG



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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194556 MJS
19-05-06

NOTES:

- CROSS REFERENCE No.'S
RED BARN No.'S + HELIPRODUCTS No.'S
RBE350A94-3700-A-01 = E-350A94-3700-40
RBE350A94-3700-A-03 = E-350A94-3700-22
RBE350A94-3700-A-05 = E-350A94-3700-21
FOR REFERENCE ONLY
- USED IN KITS:
RBE350A94-2700-05
RBEA62309

DART AEROSPACE						
TITLE SWASHPLATE IMMOBILIZING TOOL LONG BRACE						
DWG NO. RBE350A94-3700-A	REV 7					
<table border="1"> <tr> <td>MAT'L</td> <td rowspan="4">UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°</td> </tr> <tr> <td>HEAT TREAT</td> </tr> <tr> <td>FINISH</td> </tr> <tr> <td>SPEC</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°	HEAT TREAT	FINISH	SPEC
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°					
HEAT TREAT						
FINISH						
SPEC						
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R					
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING					
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009					
QA APPR: LINDSAY	USED ON MODEL					
APPROVED: GILBERT	EUROCOPTER AS350/355					
SCALE 1:5	DATE 8/21/2012 SHEET 1 OF 5					

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1A	3	LONG BRACE ASSEMBLY			2
	1		-01		TUBE	DOM		3
	1		-03		CAP	SP		4
	1		-05		FOOT	1018/1020 CR		5
	1	B/O	-07		EXTENDED POINT SET SCREW, DOG POINT	STEEL	M6 X 1 X 30mm (MCMaster-CARRER #92905A225)	2
	1	B/O	-09		REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	2
	1	B/O	-11		LANYARD	COATED STEEL	Ø1/16 X 14 (CARR LANE #CL-2-C)	2
	2	B/O	-13		FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMaster-CARR #3896T31)	2
	ASSY -1A							

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					